

Date: Thursday, 4/12/2007 8:21:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END PLATE	
Job Number	: 31653				
Estimate Number	: 10547				
P.O. Number	: N/A		Part Number	: D30671	
This Issue	: 4/12/2007 S.O. No. : N/A		Drawing Number	: D3067 REV A	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 30559		Material	: N/A	
Written By	:		Due Date	: 4/19/2007 Qty: 160 Um: Each	
Checked & Approved By	:				
Comment	: Est:03.01.21 Remove step 6 (Deburr) KJ				
	: Est Rev:B Now on Water jet 06-06-16 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S063	5052-H32 .063 Sheet	
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)	Batch: ml010510
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3067 Dwg Rev: A Prog Rev: A	ml 01 05 11
		2-Deburr if necessary	 <i>ml 01 05 11</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>ml 01 05 11</i>
			 <i>160</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <i>ml 01 05 11</i>
4.0	QC8	SECOND CHECK	 <i>ml 01 05 11</i>
			 <i>160 counted</i>
5.0	BRAKE NC	NC BRAKE	 <i>ml 01 05 11</i>
		Comment: NC BRAKE Bend as per Dwg D3067	 <i>SB : 07/06/05</i>
			<i>160</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 31653

Part Number: D30671

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



31653-05

Comment: INSPECT WORK TO NEXT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



31653-05

160
counted.

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(160)

Comment: FINAL INSPECTION/W/O RELEASE

31653-06

Job Completion



WOF 31653-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31653
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>MW</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/05/11	Date:	<i>07/05/11</i>	Date:	N/A

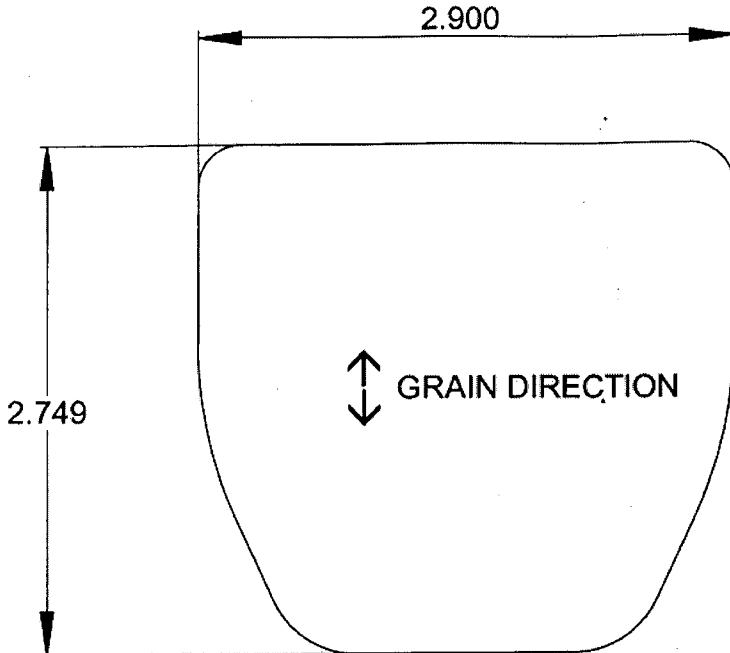
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JF



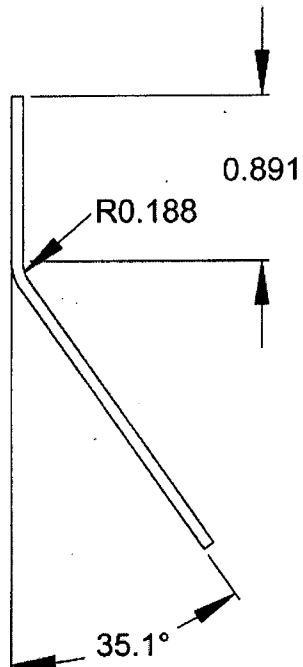
COPY ISSUE
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3067	SHEET 1 OF 1
DATE	02.09.11	TITLE	SCALE 1:1
A	02.09.11	END PLATE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31653

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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